

Date: Tuesday, 16/01/2007 9:56:56 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 30286		Part Number	: G106072	
Estimate Number	: 12644		Drawing Number	: G10607 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 16/01/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 26/01/2007	
Previous Run	: N/A		Qty:	10	Um: Each
Written By	: <u>Linda Lacelle</u>				
Checked & Approved By	: <u>Linda Lacelle</u>				
Comment	: Est Rev:A New Issue 07-01-16 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet  <b>Comment: Qty.: 0.1892 sf(s)/Unit Total : 1.8921 sf(s)</b> <b>2024-T3 .050 sheet</b> <b>*****Grain must Run Along 8.59" Dim *****</b> <b>Batch: M 103 210 - M 07 01 16</b> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>
2.0	WATER JET	FLOW WATER JET  <b>Comment: FLOW WATER JET</b> <b>1-Cut as per Dwg G10607</b> <b>Dwg Rev: A</b> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span> <b>Prog Rev: A</b> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span> <b>2-Deburr if necessary</b> <b>*****Use same cutting file for -1 &amp; -2 *****</b>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <b>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</b> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>
4.0	QC8	SECOND CHECK  <b>Comment: SECOND CHECK</b> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">(10)</span>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 1 Date: 07/18/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq.#: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS PER DWG G10607,  
\*\*\*\*NOTE:-1 & -2 ARE C'SINKED ON OPPOSITE SIDES\*\*\*\*

FF 07-01-18 10

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/18 10

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

28/4/18

07-01-22 10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/18 10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP04/04/22 10

07/01/18

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22

Job Completion



07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

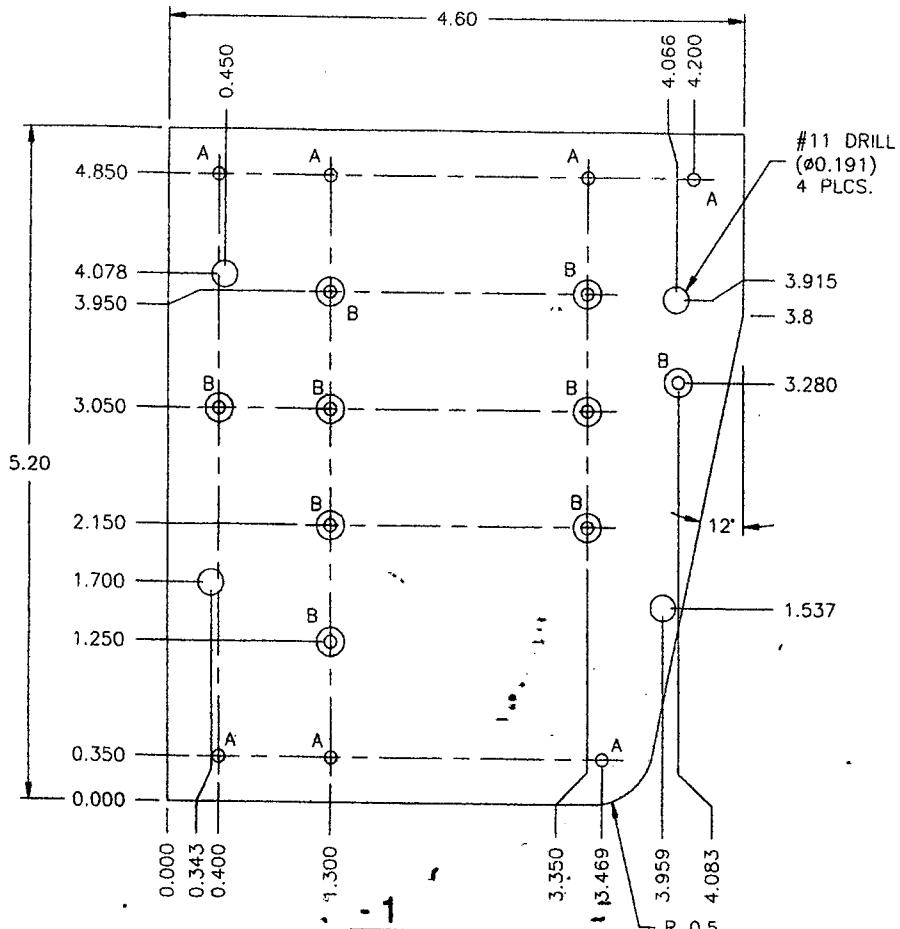
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

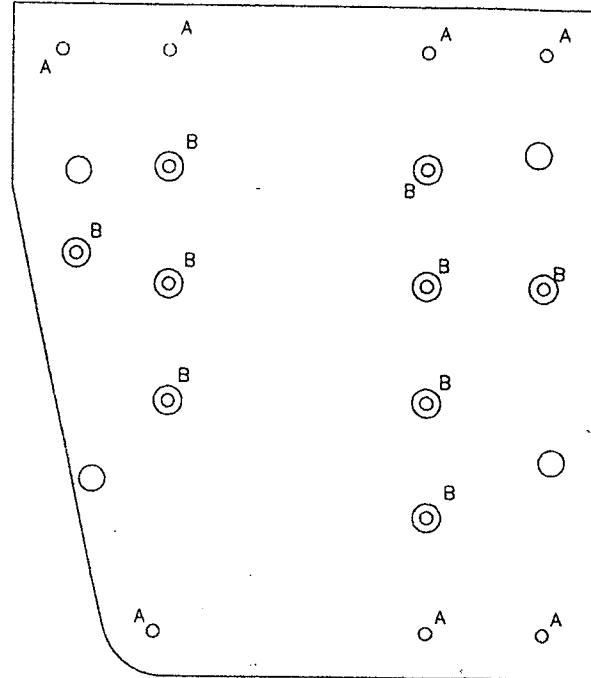
NOTE: Date & initial all entries

Stephen C. Clark, S.E.

253-385905



REV	DESCRIPTION	DATE	APROV
A	- ENLARGE ITEM -2 PICTORIAL FOR CLARIFY. - UPDATE DRAWING DIMENSIONS AND NOTES. - ECO 1038.	4/9/01	



-2

-2 SAME AS -1 EXCEPT "B" HOLES  
C'SK NEAR SIDE

BREAK ALL EDGES	DRAWN T.S.	DATE 3/25/95	GENEVA AVIATION
UNLESS OTHERWISE SPECIFIED DIMENSION ARE IN INCHES	CHECK DATE		1018 - 32nd Ave W Everett, WA 98204
DIMENSIONAL TOLERANCES	DESIGN DATE		(425)353-7400 FAX(425)347-7100
3 DECIMALS $\pm$ .010 2 DECIMALS $\pm$ .020 1 DECIMAL $\pm$ .050 ANGULAR $\pm$ 1°	APPROVAL RGC	DATE 4-3-95	TITLE DOUBLER DETAIL
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION AND SHALL NOT BE USED OR DUPLICATED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.	DWG NO. G10607	REV. A	PRO NO. GA159
	SIZE B	SCALE 1/1	SHT. 1 OF 1

DART AEROSPACE LTD	Work Order:	30286
Description: Doubler	Part Number:	G10607-2
Inspection Dwg: G10607, Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article X Prototype

Measured by:	MM:MM
Date:	01/01/16

Audited by:	
Date:	07/01/17

<b>Prototype Approval:</b>	<b>N/A</b>
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHIP TO:	
Kaiser Aluminum	
Trentwood Works - Spokane, WA 99215	
Phone: (800) 367-2598	
SOLD TO:	
THOMAS BARTON	
4062914	

**KAISER**  
**ALUMINUM**

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2598

## CERTIFIED TEST REPORT

Serial Number  
4062914

CUSTOMER PO NUMBER:		WORK PACKAGE:	CUSTOMER PART NUMBER:		SHIP UNLOAD ID:	GOVT CONTRACT NUMBER:
N18187					10082010	
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	
1083832	1	24-MAR-2008	2024	CLAD	T3	
WEIGHT SHIPPED:	QUANTITY:	INV NUMBER:	GAUGE:	WIDTH:	LENGTH:	
7885 LB	223 PCS EST.	207855	0.0600 IN	48.000 IN	1-4,000 IN	

### Certified Specifications

AMS 4041/RevP  
BATS 2505/RevNC

AMS QQ-A-2505/RevA  
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

Lot: 350042AB Cast 218

Drop 16

Ingot 2

### Test Results

Tensile:	Tempo	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	63.8 : 64.7 ✓ (441 : 446)	44.8 : 45.8 ✓ (309 : 316)	15.3 : 15.6 ✓

MRS Deflection: 0.017 IN

Chemistry:	Si /	FE /	CU /	MN /	MG /	CR /	ZN /	TI /	V /	ZR /	OTHER /
Actual	0.09	0.24	4.57	0.59	1.40 ✓	0.01 ✓	0.19 ✓	0.02 ✓	0.01 ✓	0.01 ✓	TOT 0.04

### ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.80	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.03	0.03	0.05	0.00	TOT	0.00

Aluminum Remainder

### TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS)Y CHEMICAL MILLING QUALITY (CMQ) REQUIREMENTS.



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